

# Work Order ID 52283

Tuesday, September 22, 2009 1:35:04 PM



Page 1

Item ID: D3151-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: BRACKET

Start Date: 9/23/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: PL MF Date: 09-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3151	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3151 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

10 9-10-14

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10 9-10-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 9-10-14

(10)

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Setup Start

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Start Date: 9/23/2009 Start Qty: 10.00

Required Date: 10/6/2009 Req'd Qty: 10.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start


Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	<del>Memo</del> Debur D3151-3 <i>a/n</i>								
140	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00				<i>40</i>			
Quality Control	Memo								
150	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				<i>MP 09110116</i>			
Hand Finishing	Memo					<i>210</i>			




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Item ID: D3151-3	Accept		Setup Start	
Revision ID: C			Stop	
Item Name: BRACKET				
Start Date: 9/23/2009	Start Qty: 10.00		Cust Item ID:	
Required Date: 10/6/2009	Req'd Qty: 10.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	BR 09-10-16			(10)			
170  Packaging Packaging	Identify as per dwg & Stock Location: 67  Memo	0.00 0.00				9/10/16	(100)		sf
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							09/10/19 HJ MF 09-10-19

# Picklist Print

Page 1

Tuesday, September 22, 2009 1:35:04 PM

Work Order ID: 52283



Parent Item: D3151-3RevC



Parent Item Name: BRACKET

Start Date: 9/23/2009

Required Date: 10/6/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	220.2565	263.1579			



2024-T3 .040 sheet



B 9-10-14

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

220.2564789

110337

6.4

111786

39.0665789

112291

91.9258

112331

82.8641

111786

D3065-5DART AEROSPACE LTD		Work Order:	52283
Description: Doubler Assembly		Part Number:	D3151-3
Inspection Dwg: D3151 Rev: C		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	✓			
Ø0.250	+0.005/-0.001	.252	✓			
Ø0.700	+0.008/-0.001	.701	✗			
2.75	+/-0.030	2.747	✗			
6.76	+/-0.030	6.762	✗			
6.060	+/-0.010	6.063	✗			
1.075	+/-0.010	1.077	✓			
3.305	+/-0.010	3.303	✓			
0.350	+/-0.010	.346	✓			
0.688	+/-0.010	.691	✓			
0.344	+/-0.010	.346	✓			
1.480	+/-0.010	1.480	✓			
2.150	+/-0.010	2.148	✓			
3.800	+/-0.010	3.801	✗			
1.975	+/-0.010	1.976	✗			
0.350	+/-0.010	.351	✓			
0.475	+/-0.010	.477	✓			
1.800	+/-0.010	1.800	✓			
2.050	+/-0.010	2.048	✓			
1.375	+/-0.010	1.375	✗			

Measured by: <b>ib</b>	Audited by: <b>S</b>	Prototype Approval:	N/A
Date: <b>9-10-14</b>	Date: <b>09/10/14</b>	Date:	N/A

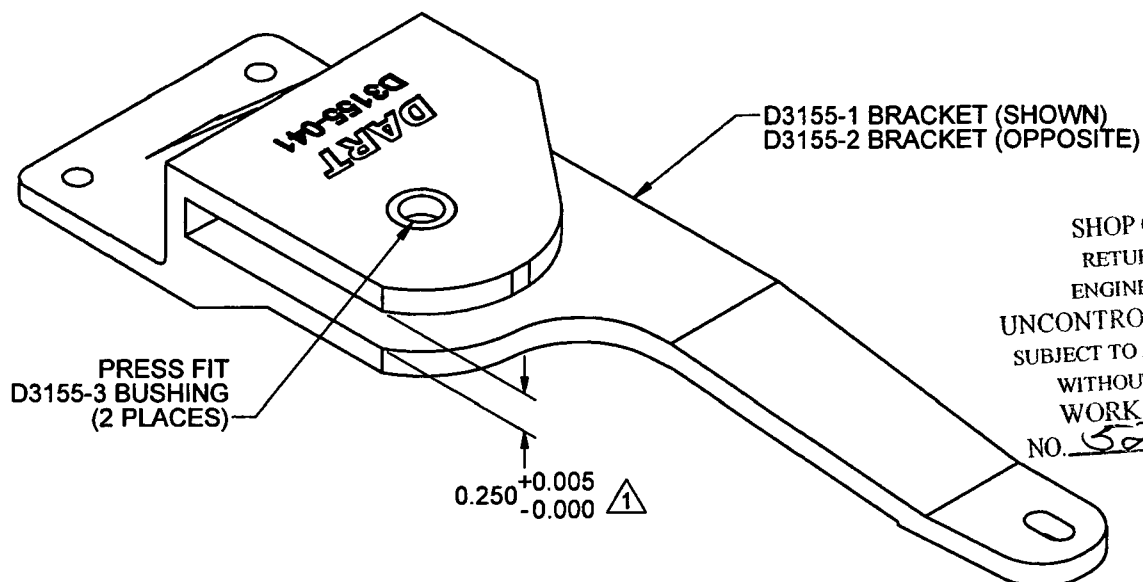
Rev	Date	Change	Revised by	Approved
A	08.05.20	New Issue	KJ/DD <b>[Signature]</b>	<b>[Signature]</b>

**DART**

DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3155	REV: D SHEET 1 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:1
REV	DATE	DESCRIPTION	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	
D	07.01.18	ON D3155-1/-2, 0.699 DIM WAS REMOVED; 0.887 WAS 0.882; 3.150 WAS 3.148; ADD 0.250 DIM +0.005/-0.000	

**RELEASED**

07.01.18 [Signature]



**D3155-041 BRACKET ASSEMBLY**  
(SHOWN, REPLACE PREMIER P/N B30-23000-11)  
**D3155-042 BRACKET ASSEMBLY**  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3155-041	BRACKET ASSEMBLY
	X	D3155-042	BRACKET ASSEMBLY
1		D3155-1	BRACKET
	1	D3155-2	BRACKET
2	2	D3155-3	BUSHING

**NOTE:**

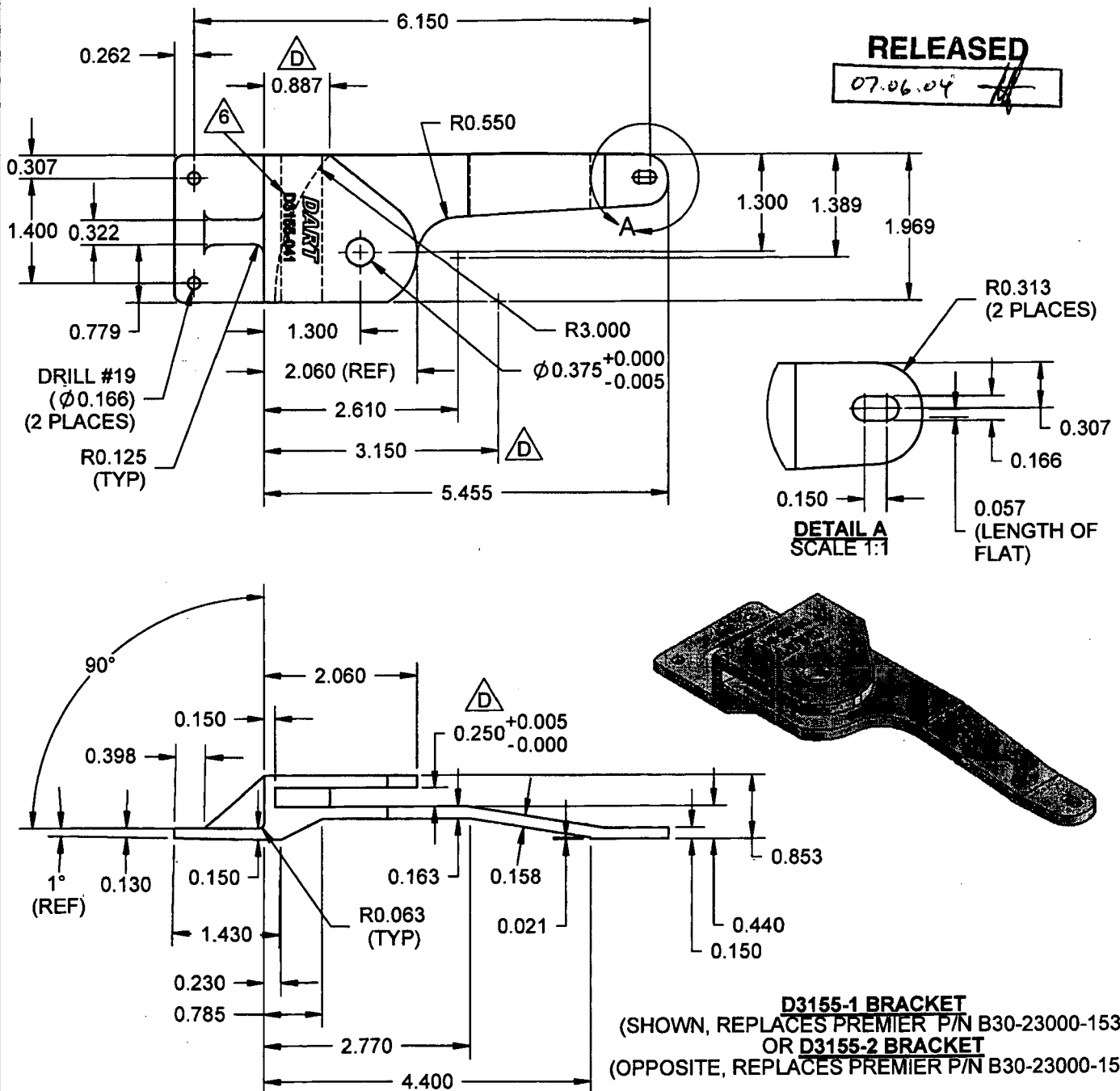
⚠ MAINTAIN THE 0.250<sup>+0.005</sup>/<sub>-0.000</sub> DIMENSION AFTER PRESS FITTING THE BUSHING.

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**DART**

DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. <b>D3155</b>	REV. D SHEET 2 OF 3
DATE <b>07.01.18</b>	TITLE <b>BRACKET ASSEMBLY</b>		SCALE 1:2

**NOTES:**

- 1) MATERIAL: ALUMINUM BAR 6061-T6/-T651 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117 OR AMS 4128 OR AMS 4115 OR AMS 4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN TO MAX DEPTH OF 0.010 WITH A MIN RAD OF 0.010

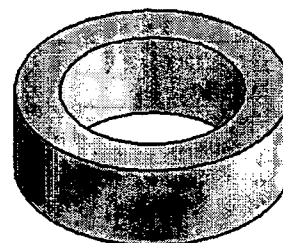
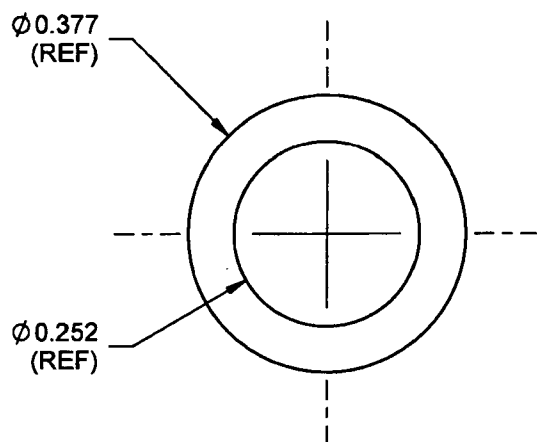
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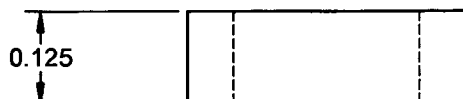
52283

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D3155</b>	REV-D SHEET 3 OF 3
DATE <b>07.01.18</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 4:1



**RELEASED**

07.06.04 *CH*



### **D3155-3 BUSHING**



**NOTES:**

- 1) MATERIAL: MAKE FROM SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)  
POSSIBLE SUPPLIER: SYMMCO
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3151	REV. C SHEET 1 OF 1
DATE 05.12.07		TITLE DOUBLER ASSEMBLY	SCALE 1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	
C	05.12.07	REVISE NOTES	

MS20426AD3-3 RIVET (1)  
(6 PLACES)


MS21059L08 NUTPLATE (1)  
MS20426AD3-4 RIVET (2)  
(2 PLACES)

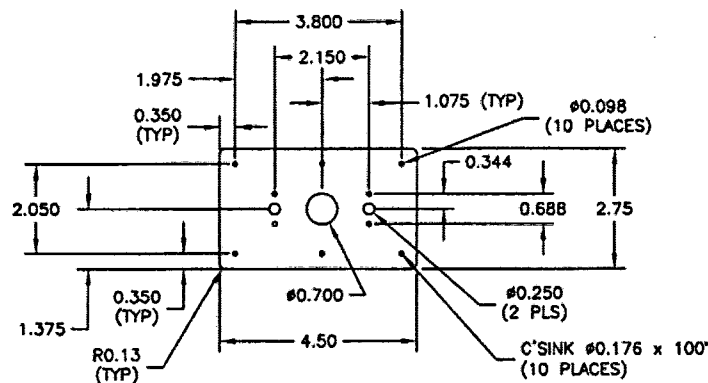
D3151-3

D3151-1

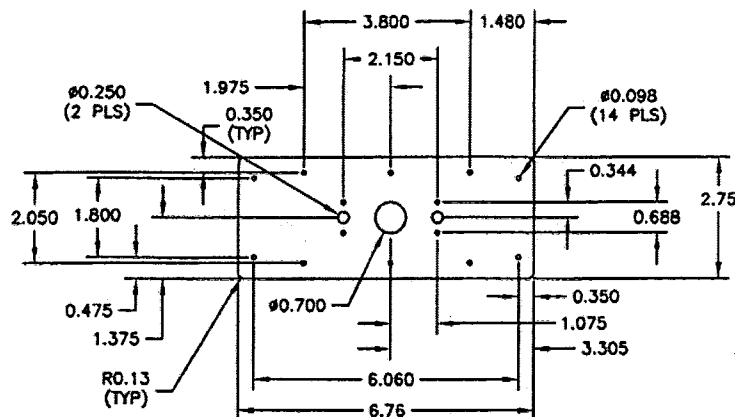
**D3151-041 DOUBLER ASSEMBLY**  
REPLACES PREMIER P/N 830-23000-173/-174

**RELEASED**

05.12.07 



**D3151-1**



**D3151-3**

**NOTES**

- 1) MATERIAL: 2024-T3 SHEET (00-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

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